







Work Order ID 62846

Tuesday, October 12, 2010 11:22:53 AM

Page 1


Item ID:	D4172-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Support Angle					
Start Date:	10/12/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	10/15/2010	Req'd Qty:	1.00	Customer:		
Reference:						


Approvals:	Process Plan:		Date:	10-10-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4172	A								

100		0.00							
									
Small Fab									

Small Fab	Memo	0.00							
	1- Cut to length as per dwg								
	2- Use DT9657 to drill holes in angle, open to size as per dwg								
	3- C'sink holes as per dwg								
	4- Deburr holes								

110	QC5- Inspect part completeness to step on W/O	0.00							
									
QC									
Quality Control	Memo	0.00							

120	Chemical Conversion Coat per QSI005 4.1	0.00							
									
HandFinish									
Hand Finishing	Memo	0.00							

18

⇒ m-l 10/10/12

8/10/10/12

XL
-3

10-10-12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62846

Tuesday, October 12, 2010 11:22:53 AM

Page 2

Item ID: D4172-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Support Angle

Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location *Composites* 0.00

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/10/12 *[Signature]*

mf 10-10-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 11:22:57 AM

Page 1

Work Order ID: 62846



Parent Item: D4172-3



Parent Item Name: Support Angle

Start Date: 10/12/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125		Purchased	No			100	f	57.5137	6.25	6.578947			
6061T6 ANGLE 1.00 x 1.00 x .125W													

Location

MAT

115688

115776

Loc Qty

57.51369

4.331053

53.182637

Loc Code

6.578947

mtb 10/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

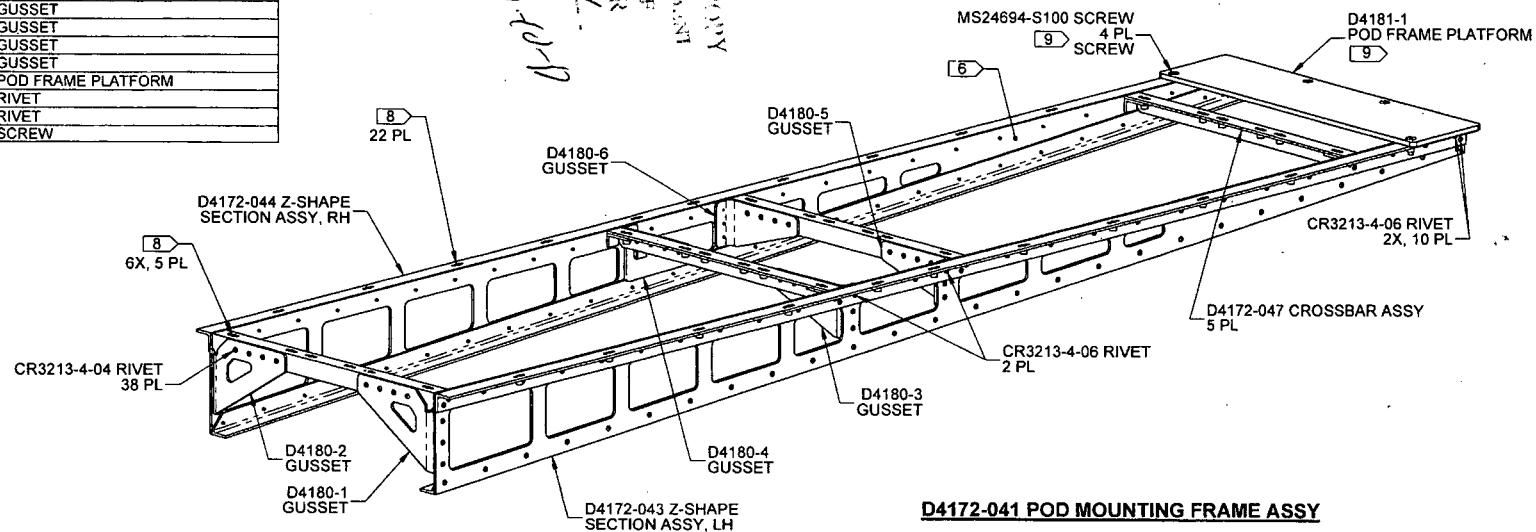
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

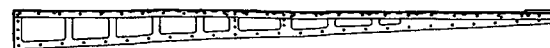
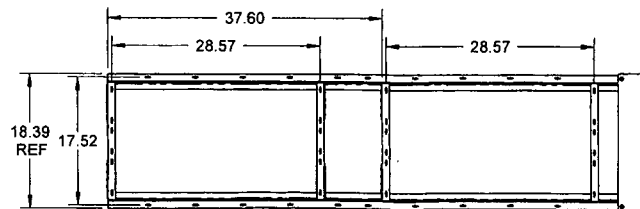
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S100	SCREW



D4172-041 POD MOUNTING FRAME ASSY



SUPPLEMENTAL VIEWS

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 15.0 lbs
- 8) MASK PRIOR TO POWDER COATING
- 9) INSTALL AFTER POWDER COATING

RELEASED
2010-09-29

REV.	DESCRIPTION	MB	DATE
A	NEW ISSUE		10.09.15
DESIGN		BY	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4172** REV. A
SHEET 1 OF 7
TITLE **POD MOUNTING FRAME ASSY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

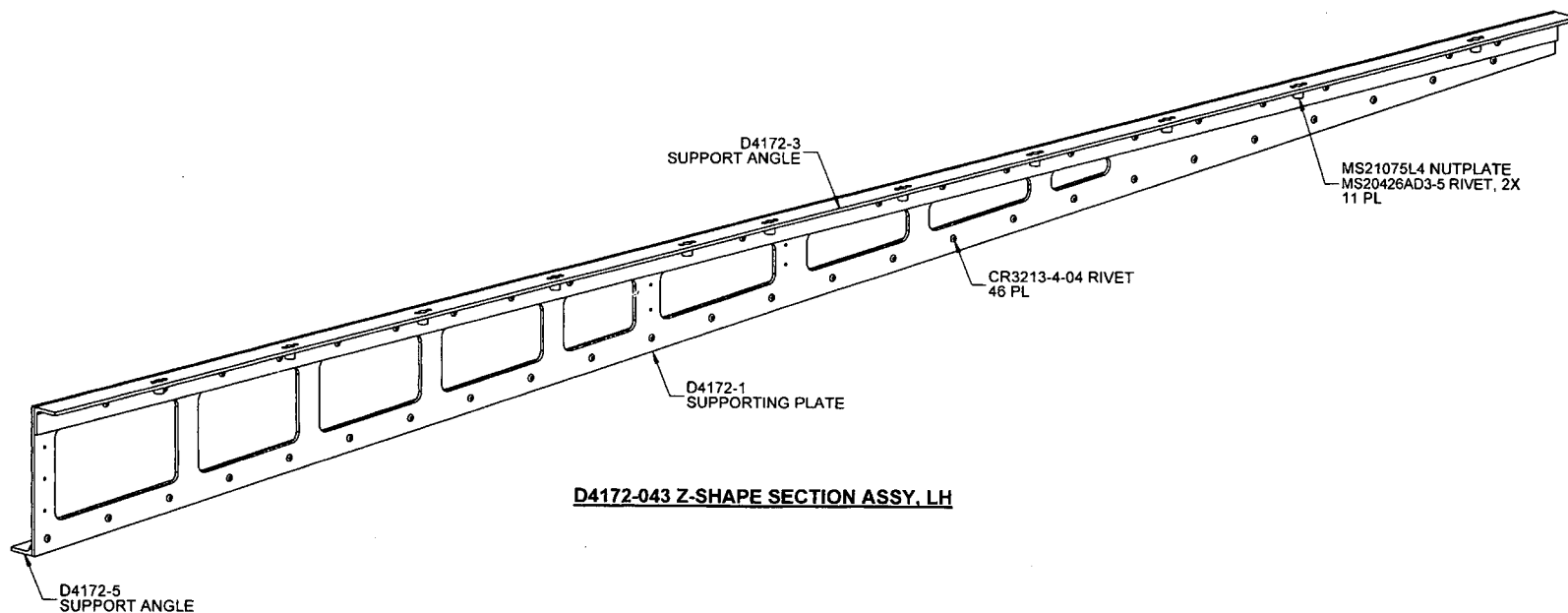
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.13 lbs

DESIGN	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J		
CHECKED	D	DRAWING NO. D4172	REV. A
MFG. APPR.	D	SHEET 2 OF 7	
APPROVED	D	TITLE	SCALE
DE APPR.	D	POD MOUNTING FRAME ASSY NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

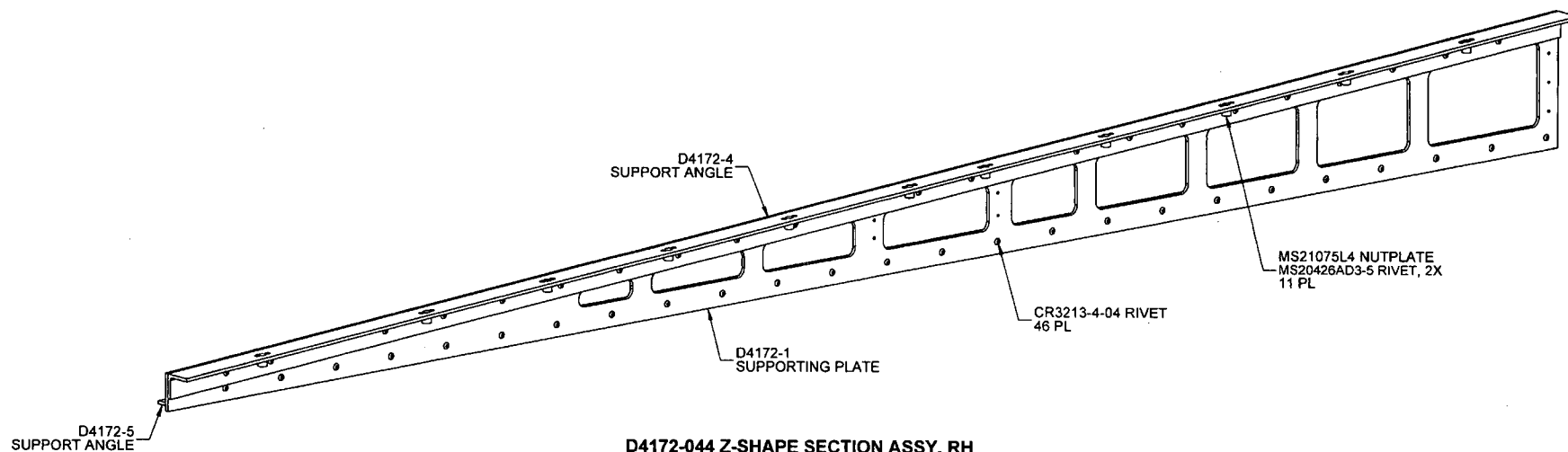
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .044	P/N	DESCRIPTION
	X	D4172-044	Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



D4172-044 Z-SHAPE SECTION ASSY, RH

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.14 lbs

RELEASED
2010-09-29

DESIGN	J	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. A
MFG. APPR.	R	D4172	SHEET 3 OF 7
APPROVED	100	TITLE	SCALE
DE APPR.	11	POD MOUNTING FRAME ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

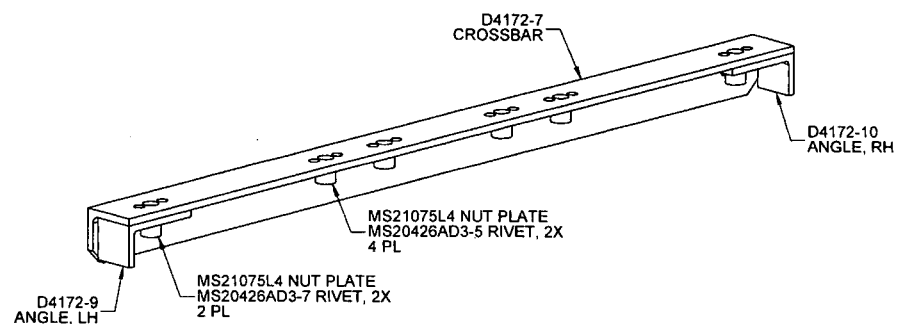
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET
6	4	MS20426AD3-7	RIVET



D4172-047 CROSSBAR ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

DESIGN	JL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO. D4172	REV. A
MFG. APPR.	JS	SHEET 4 OF 7	
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	POD MOUNTING FRAME ASSY NTS	
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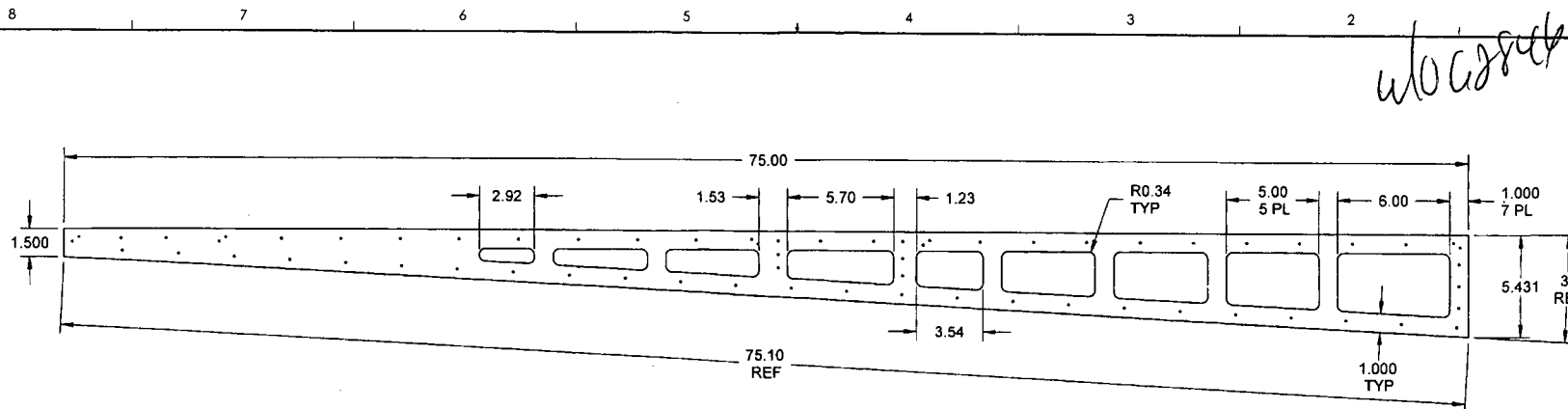
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

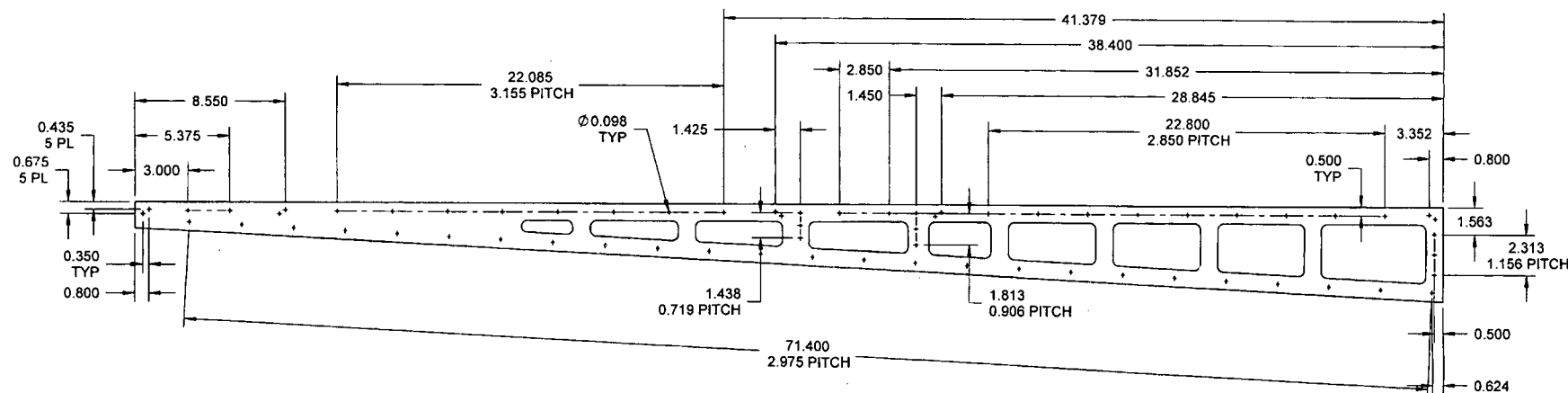
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4172-1 SUPPORTING PLATE



SUPPLEMENTAL VIEW

RELEASED
2010-09-29

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.78 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4172	REV. A
MFG. APPR.			SHEET 5 OF 7
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DE APPR.		POD MOUNTING FRAME ASSY	NTS
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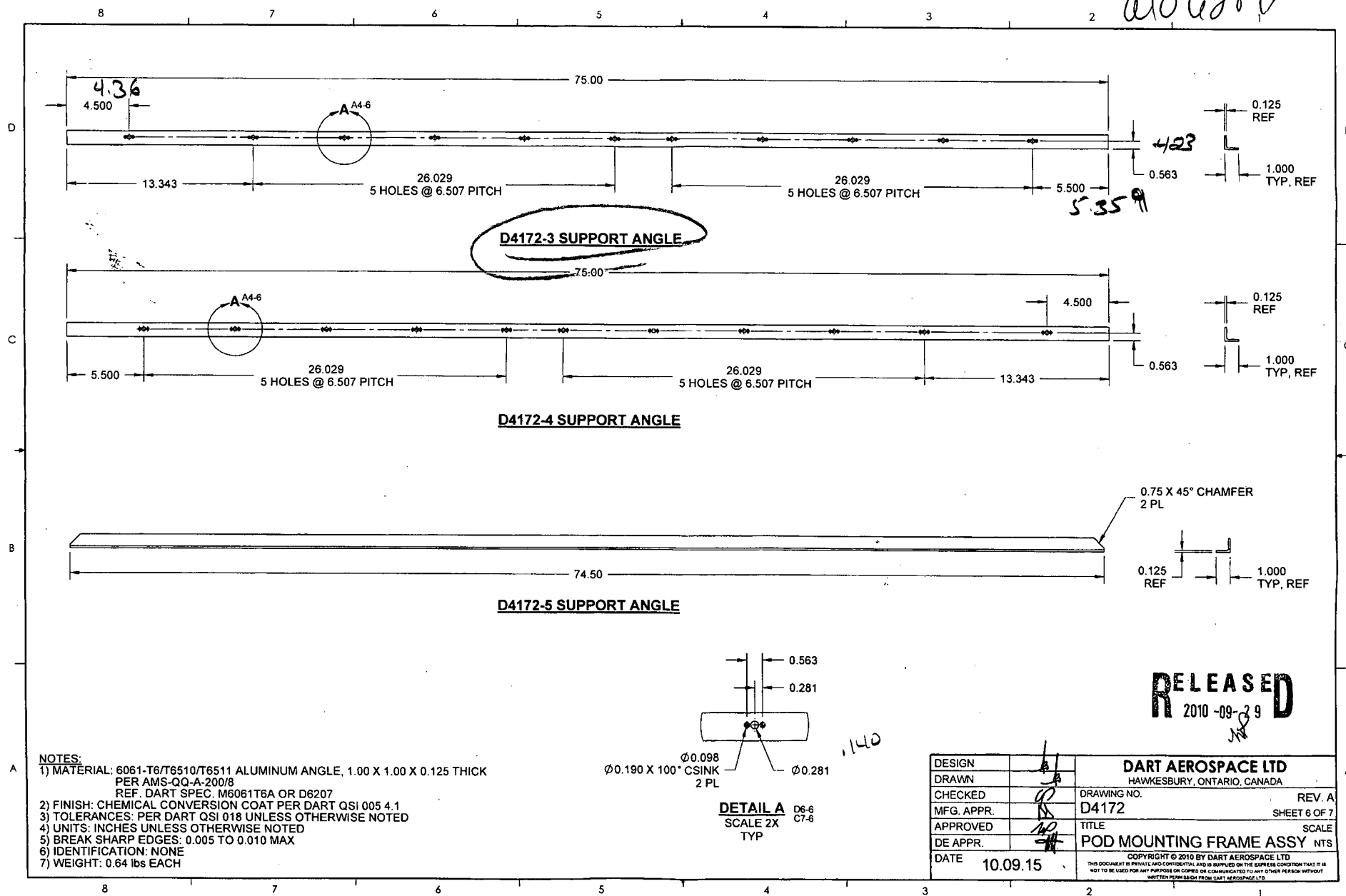
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

alo 62846



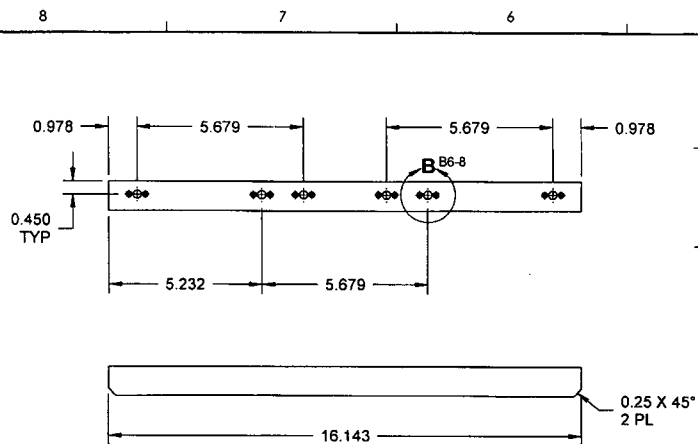
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

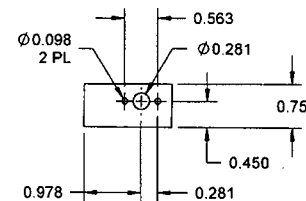
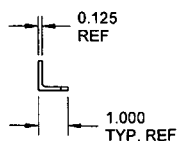
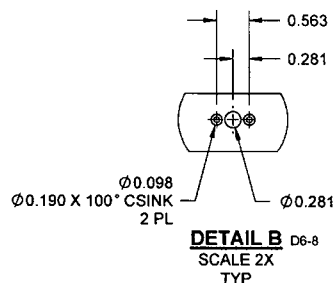
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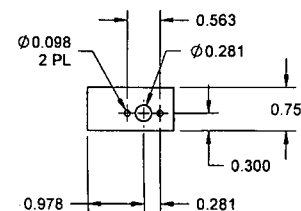
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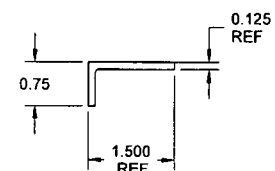
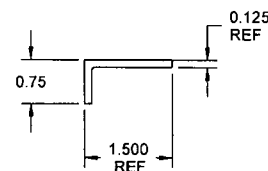
D4172-7 CROSSBAR



D4172-9 ANGLE



D4172-10 ANGLE



NOTES:

- 1) MATERIAL
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

RELEASED
2010-09-29

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4172	REV. A
MFG. APPR.		SHEET 7 OF 7	
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	
DATE	10.09.15	NTS	

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